



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D412-664-203TRN
Job Sheet 173472



Part No: D412-664-203TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F IPP Rev:A 08-03-06 new issue DD verified by:eec IPP Rev B 08.04.02 Removed polish EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Crosstubes-2		M.D.
100	Mori Seiki	1 pcs	3/22/18	3/22/18	3.21	1.33	Mori Seiki TL-40		M.D. DAS
110	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC2-3		M.D. 56
120	Mori Seiki	1 pcs	3/22/18	3/22/18	0.00	1.67	Mori Seiki TL-40		M.D. 18.89
130	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC2-3		M.D. 18.89
140	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC8		GP 18-06-29
145	Crosstubes	1 pcs	3/22/18	3/22/18	0.00	0.25	Crosstubes-2		GP 18-09-09
150	HandFXtube	1 pcs	3/23/18	3/23/18	0.00	0.92	HandFinish5		D.P. 18/09/09
160	QC	1 pcs	3/23/18	3/23/18	0.00	0.00	QC7-3		GP 2018-09-05
170	Packaging	1 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3-2		GP 2018-09-05
180	QC21-SA	1 Ea	3/23/18	3/23/18	0.00	0.00	QC21		GP 18-09-07

Part Op 100 - 1-Fill tube with sand & install plugs 412-203 on both ends as per Folio FA166 2-Face both sides of tube 3-Turn first Descriptions: taper section on both side as per Folio FA166 4- blend transition lines using belt sander with 60 grit sandpaper
120 - 1-Turn second taper on both sides as per Folio FA166 2- Blend transition lines using belt sander with 60 grit sandpaper. 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stylus
145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - 1- handfinish X-TUBE INSIDE AND OUT
170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6009-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

8123972

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6009-129	1	103	0

Part Specifications

Specifications could not be found.

Plex 3/2/18 9:54 AM Dart.Gagnon.Michelle



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CANADA
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www.dartaerospace.com

Container No: S083097



Part: D412-664-203TRN

Job No: 173472

Serial No/Batch: S083097

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 06/21/18

②

DART AEROSPACE LTD	Work Order:	173472
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: F		Page 1 of 2

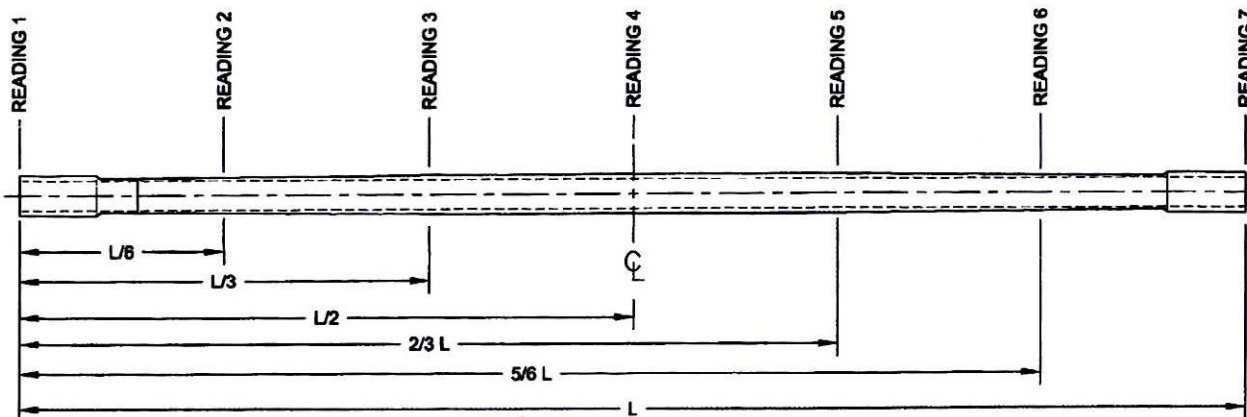
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689	✓		BLM 3" 04	
	2.748	+0.005/-0.000	2.753	✓		"	
	2.884	+0.005/-0.000	2.889	✓		"	
	3.019	+0.005/-0.000	3.024	✓		BLM 4" 05	
	3.163	+0.005/-0.000	3.167	✓		BLM 4" 05	
	3.308	+0.005/-0.000	3.313	✓		BLM 4" 05	
	3.429	+0.005/-0.000	3.434	✓		BLM 4" 05	
	2.990	+0.005/-0.000	2.9935	✓		BLM 3" 04	
	2.618	+0.005/-0.000	2.622	✓		BLM 3" 04	
	0.200	+/-0.010	.207	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		RG	
	4.971	+/-0.030	4.974	✓		Vern 08	
SIDE B	2.684	+0.005/-0.000	2.689	✓		BLM 3" 04	
	2.748	+0.005/-0.000	2.753	✓		"	
	2.884	+0.005/-0.000	2.889	✓		"	
	3.019	+0.005/-0.000	3.024	✓		BLM 4" 05	
	3.163	+0.005/-0.000	3.167	✓		BLM 4" 05	
	3.308	+0.005/-0.000	3.313	✓		BLM 4" 05	
	3.429	+0.005/-0.000	3.434	✓		BLM 4" 05	
	2.990	+0.005/-0.000	2.993	✓		BLM 3" 04	
	2.618	+0.005/-0.000	2.622	✓		"	
	0.200	+/-0.010	.203	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		RG	
	4.971	+/-0.030	4.976	✓		Vern 08	
	124.100	+/-0.020	124.100	✓		Tape	

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DART AEROSPACE LTD	Work Order: 173472
Description: Crosstube Assembly (412 High Aft)	Part Number: D412-664-243
Inspection Dwg: D412-664-243 Rev: F	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.357	.368	.379	.367	.022	0.073"
READING 2 L= 20.683	.301	.321	.314	.290	.031	
READING 3 L= 41.367	.469	.482	.481	.469	.013	
READING 4 L= 62.050	.620	.634	.639	.633	.019	
READING 5 L= 82.733	.492	.485	.475	.483	.017	
READING 6 L= 103.417	.312	.309	.301	.302	.011	
READING 7 L= 124.100	.356	.369	.375	.363	.019	

Calibration Result

Actual Block Thickness: 100-750

Sitescan 250 Measured Thickness: 100-750

Measured by: M.D. ^{DAS 56 9-89}	Audited by: GP	Preliminary Approval:
Date: 2018-06-20	Date: 18-06-29	Date:

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	
D	10.02.02	Dimension 124.100 was 124.09	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	14.06.24	Dwg Rev updated	KJ	

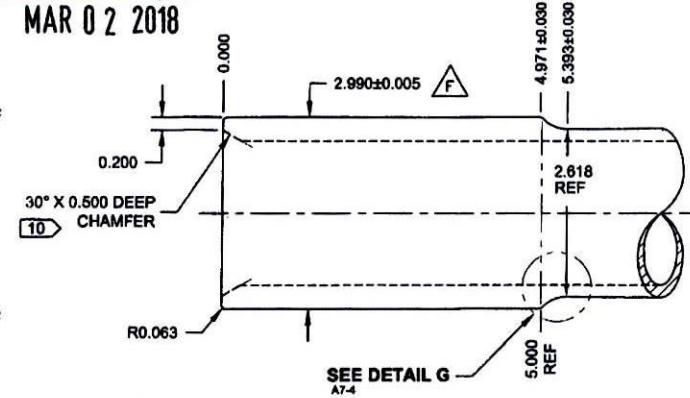
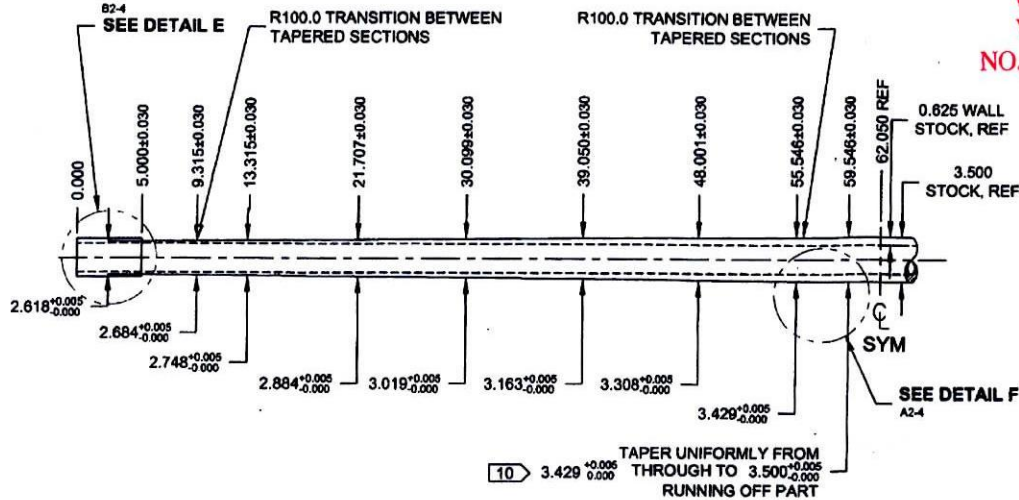
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

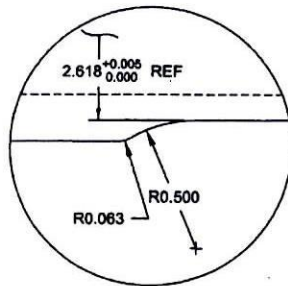
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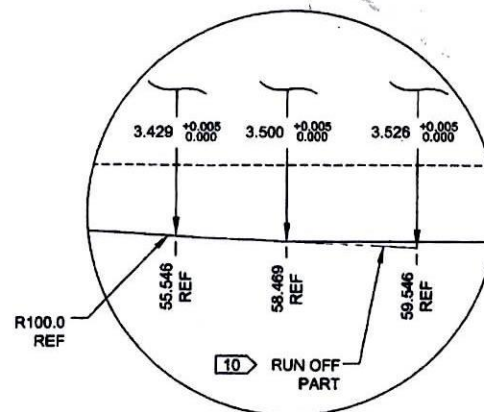


D412-664-243TRN
TURNING DETAIL

DETAIL E:
CROSSTUBE CUFF
SCALE 5X



DETAIL G:
CUFF TRANSITION
SCALE 10X



DETAIL F:
TAPER RUN-OFF
NOT TO SCALE

RELEASED
2014-05-26

DESIGN	<i>qp</i>	DART AEROSPACE LTD	
DRAWN	<i>qp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>qp</i>	DRAWING NO. D412-664-243	REV. F
MFG. APPR.	<i>qp</i>		SHEET 4 OF 4
APPROVED	<i>qp</i>	TITLE	SCALE
DE APPR.	<i>qp</i>	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	